



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

006700

646.4001
Job Sheet 185750



3 ✓

Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Stores/Pkg-1			NOV 28 2018 DEC 12 2018
110	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging1-1			DEC 12 2018
120	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC4			DEC 12 2018
130	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1			DEC 12 2018
135	DC	1 pcs	12/14/18	12/14/18	0.00	0.00	DC			DEC 12 2018
140	QC21-FG	1 Ea	12/14/18	12/14/18	0.00	0.00	QC21			DEC 12 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4001 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5135806
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5135809
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5130299
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5119441
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125414
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	5117183
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	5091495
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5119224
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5081641
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5063686
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5072241
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	5049669
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5068766
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5038797
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	5042029
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	5038824
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	5072442
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5063780
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	5038801
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5064802

10/10/19
Exp 5/19

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		☐ Rework ☐ Scrap ☐ Use-as-is		☐ Skid-tube ☐ Machining ☐ Thermoforming	
NCR No. _____		☐ Cross tube ☐ Small Fab ☐ Finishing		☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rep/Strain Installation	
Date: _____ Step #: _____		☐ Engineering ☐ Quality ☐ Other		☐ MRB (QSI042) Approval	
Description Work Order		☐ Completed By		☐ Lead hand / Supervisor ☐ Approval Verification	
Root Cause		DART Aerospace Container No: S137023 Part: 646.4001 Job No: 185750 Serial No/Batch: S137023 Revision: Inspector: Exp Date: 05/11/2019 Instructions: FAA STC SR02180LA 14/08/07/21/16 STC SH09 -		QC / QA Coordinator Approval	
Environment		Pre		Positioned Wrong	
Design		Operator		Outside Dimensions	
Doc/Data		Offset/Setup		Over/Under tolerance	
Equip/Tooling		Supplier		Part Incorrect	
Handling/Pre		Training		Part Lost/Missing	
Material		Use for Testing		Part Moved	
Internal Transport		Poor Information		Drawing	
Tribal Knowledge		Rushing		Finish	
LOA		Product Improvement		Misread	
Substation		Process Improvement		Turning Sequence	
Past Expiry Date		Manufacturing Process			
Misidentified		Past Due			
OTHER:					

306 185750

(006700)

3

646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation	5063754
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation	5118787X11
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5070843
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation	5131074
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation	5131076
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5013258
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5124377
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5041250
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5128109
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5041498
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5056998
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5097192
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5128424
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5122789
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5130322
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5095479
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation	5098032
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation	5131193
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5112901
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5103950
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5080637
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5104032
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5095478
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation	5131214
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation	5103962
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	5108575
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation	5153848
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation	5113406
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation	5124089
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5123425
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation	5100409
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5094572
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation	5109736
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5103943
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5004859
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5118746
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5099526
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5071834
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5006976
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5104364
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5131198
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5094554
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation	5104041
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation	5131201
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5075330
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	5123456
				510746

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	264	0
	600.0990	1	15	0
	600.0991	1	13	0
	600.1012	1	26	0
	600.1013	5	74	0
	646.2910	1	25	0
	646.3001	1	8	0
	646.3110	1	12	0
	646.3210	1	14	0
	646.3301	1	12	0
	646.3510	1	17	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

2ART
AEROSPACE

QA Closed: _____ Date: _____

Date:

QA Closed:		Date:		AGAINST DEPARTMENT/PROCESS	
Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	
Part No. _____				Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	
NCR No. _____		QTY Effective :		Water Jet ☐ Prod. Eng. Coord. ☐ Rec./Store/Packaging ☐ Supplier ☐	
Date : _____		Step #:		Engineering ☐ Quality ☐ Other ☐	
Description Work Order Deviation				Disposition	
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	
		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	
				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :					

646.3511	1	22	0
646.3610	1	22	0
646.3710	1	48	0
646.3711	1	32	0
646.3712	1	20	0
646.3713	1	15	0
646.3714	1	21	0
646.3715	2	29	0
646.3716	1	38	0
646.3717	1	24	0
646.3718	2	40	0
646.3719	2	32	0
646.3810	2	19	0
646.3811	1	29	0
646.3812	2	14	0
646.3813	1	11	0
646.3910	4	35	0
646.3911	1	21	0
646.3912	4	32	0
646.3913	1	37	0
646.9410	1	99	0
647.0112	2	84	0
647.7703	2	16	0
650.9201	2	33	0
AN3-11A	10	155	0
AN3-12A	2	92	0
AN3-13A	1	97	0
AN3-3A	4	206	0
AN3-4A	10	366	0
AN3-5A	2	322	0
AN3-6A	2	196	0
AN316C4R	2	35	0
AN44-5A	2	29	0
AN4C7A	2	141	0
AN665-34R	2	27	0
CCR264SS3-02	36	599	0
CR3213-5-3	14	260	0
MS20426AD5-7	2	1,014	0
MS20470AD5-5.5	8	234	0
MS20470AD5-6	8	1,017	0
MS20470AD5-7	3	140	0
MS21042L08	2	1,956	0
MS21042L3	63	2,260	0
MS21042L4	2	3,367	0
MS21047-3	18	472	0
MS24693-C278	5	144	0
MS24694-S51	5	300	0
MS24694-S54	2	408	0
MS24694-S55	3	101	0
MS27039-08-13	2	80	0
MS27039-1-10	2	137	0
MS27039-1-12	6	85	0
MS27039-1-16	24	597	0
MS27039-1-19	22	351	0
MS27039-1-20	2	105	0
MS27039-1-21	4	114	0
NAS1149F0332P	144	2,061	0
NAS1149F0363P	2	562	0
NAS1149F0432P	4	1,422	0
NAS1149FN832P	4	2,779	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____		Step #: _____		QTY Effective: _____		MRB (QS1042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER: ☐			

